

Work Order ID **55957**

February 8, 2010 11:40:06 AM



Page 1

Item ID: D4055-3

Accept



Setup Start



Revision ID:

Item Name: Tank Aft End

Stop



Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr D4055	Revision Nbr PA1 Rev A	0.00							Pt 10-2-08
100 Purchasing	Memo Issue P/O: 11330 Purchase part as per Dwg D4055 Possible Supplier: GFI Material release note required	0.00							③
110 Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00							10/3/4 ③
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo Diolos to print. Day only	0.00 0.00							Rev A doesn't match P.A1 QC APPROVAL 8/10/08 PRELIMINARY ISSUE

WIO: 55957

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/4/22		PA 1 to "Rev A" has differences. No 0.180" (4.5mm) hubs in the corners of the parts.					S 10/4/22

Part No: D4055-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: *10/4/22* *Prologue*

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Scrap parts. Parts are not the same same as PA 1 to Rev A.		- Destroy Part.				S 10/4/22

NOTE: Date & initial all entries

Work Order ID 55957

February 8, 2010 11:40:06 AM



Page 2

Item ID: D4055-3

Accept



Setup Start



Revision ID:

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Stop



Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

0.00

0.00

0.00

0.00

0.00

0.00

Memo

0.00

WJS

B 10.03.08

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

0.00

150



Packaging

Packaging

Identify as per dwg & Stock Location:

Prel.

0.00

Memo

Shelf.

0.00

10.04.13

③

Work Order ID 55957

Page 3

February 8, 2010 11:40:07 AM

Item ID: D4055-3

Accept



Setup

Start



Revision ID:

Item Name: Tank Aft End

Stop



Start Date: 2/08/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/22/10 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

 2/10-4-14
(3)

POSITIVE RECALL

EFFECTIVE 2/02/08 AUTH U

RELEASED _____ DATE _____

Picklist Print

Page 1

February 8, 2010 11:40:05 AM

Work Order ID: 55957



Parent Item: D4055-3



Parent Item Name: Tank Aft End

Start Date: 2/08/10

Required Date: 2/22/10

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM

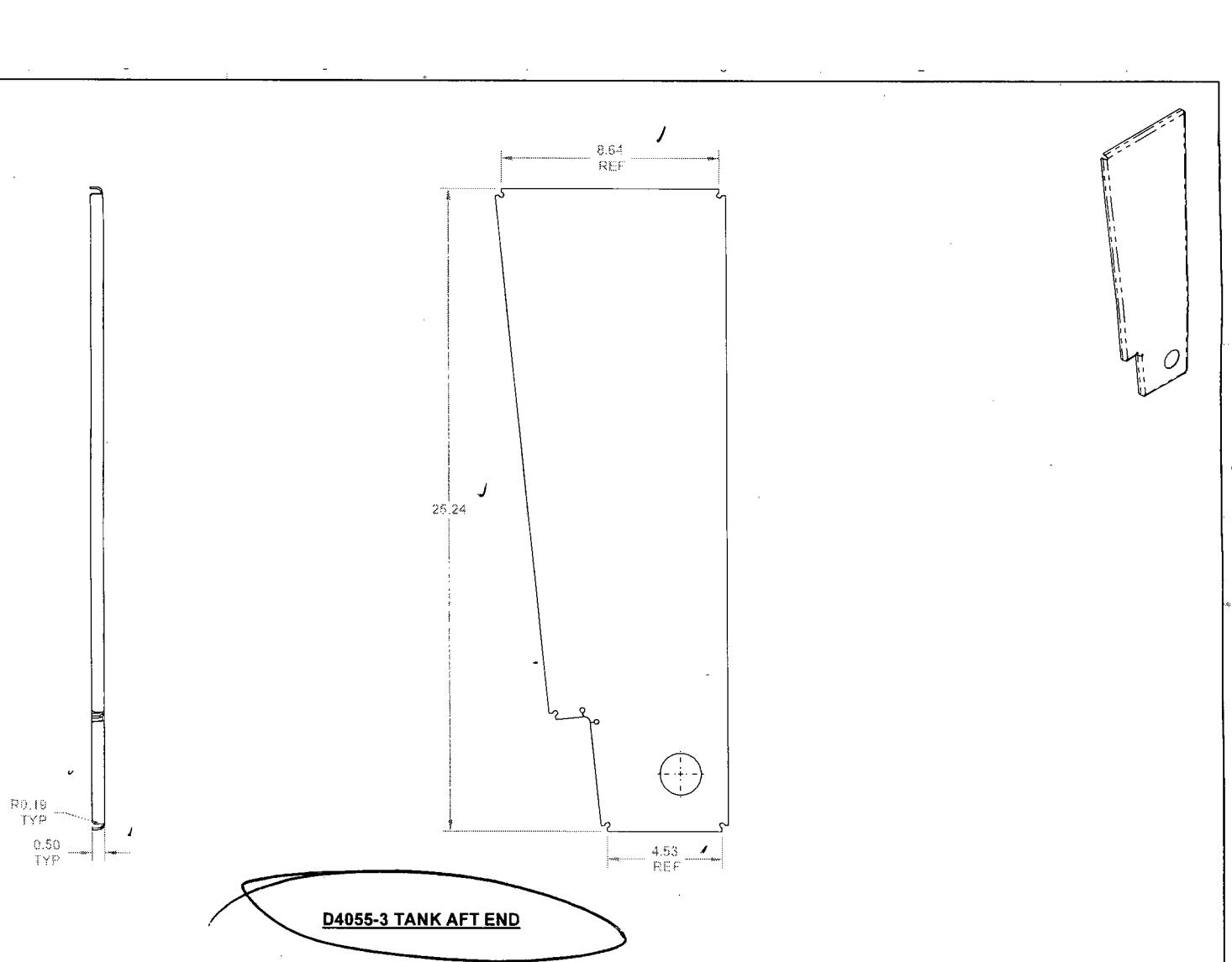
Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4055-3P		Purchased		No		110	Each	0.0000	3.0000			

Tank Aft End

W
D
55055



PRELIMINARY ISSUE

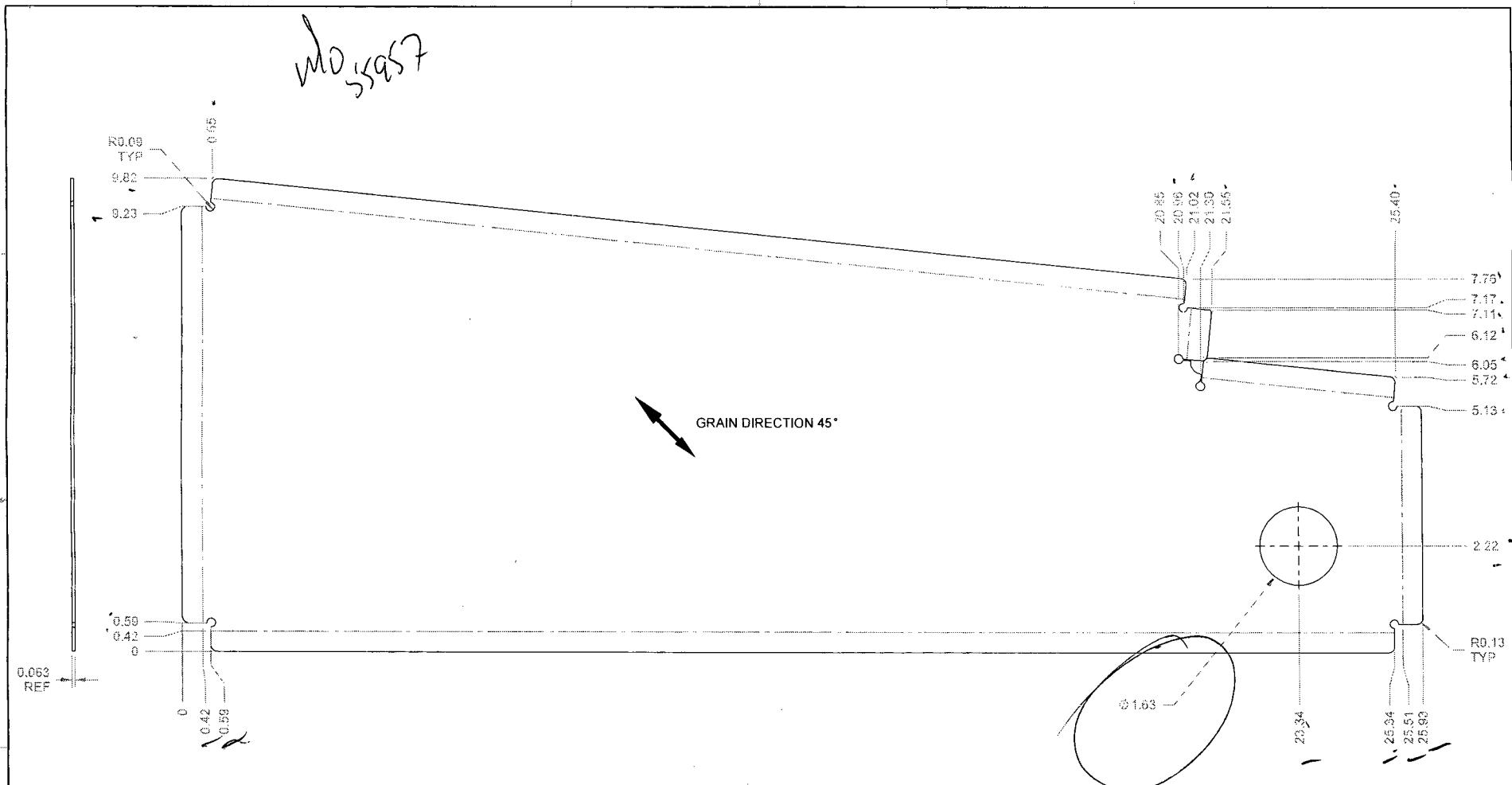
10.01.11

NOTES:

- 1) MATERIAL: MADE FROM D4055-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

DESIGN	DART AEROSPACE LTD		
DRAWN	HAWKESBURY, ONTARIO, CANADA		
CHECKED	REV. PA1		
MFG. APPR.	SHEET 6 OF 15		
APPROVED	TITLE		
DE APPR.	SCALE		
DATE	10.01.11		

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D4055-3F FLAT PATTERN

NOTES:

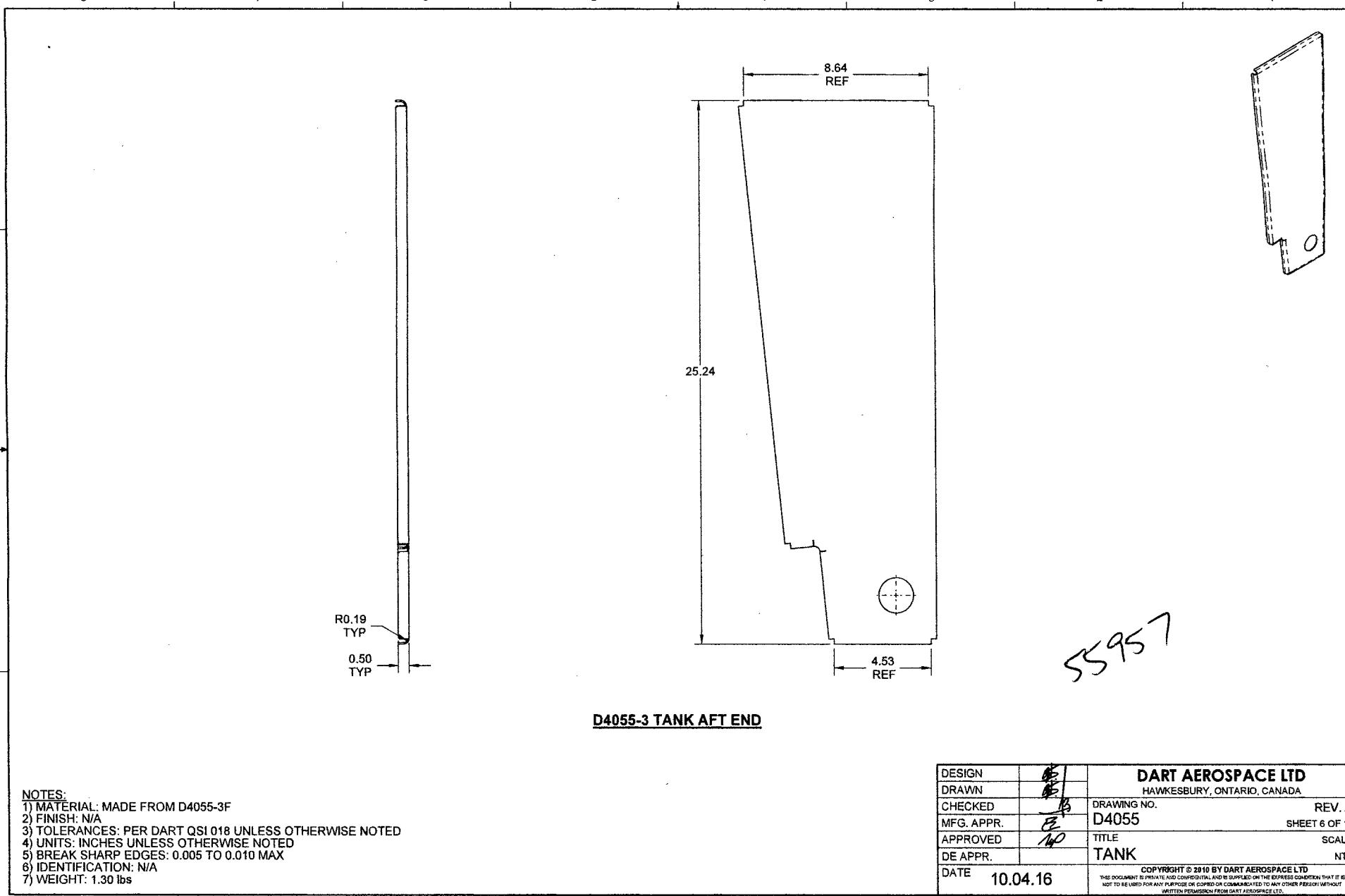
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.30 lbs

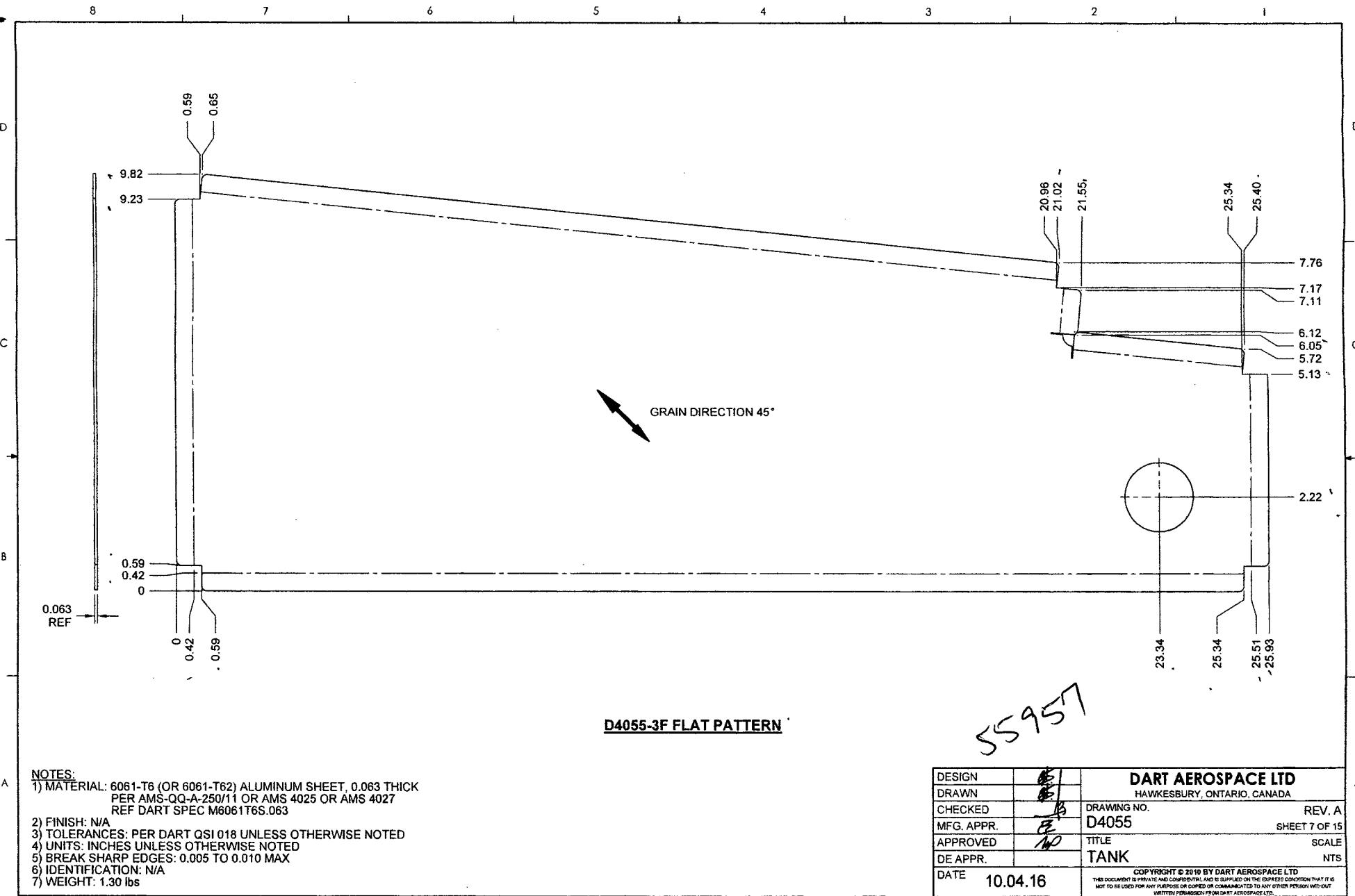
PRELIMINARY ISSUE

10.01.11

DESIGN	DART AEROSPACE LTD				
DRAWN	HAWKESBURY, ONTARIO, CANADA				
CHECKED	DRAWING NO.	REV. PA1			
MFG. APPR.	SHEET 7 OF 15				
APPROVED	TITLE	SCALE			
DE APPR.	1:8				
DATE	10.01.11				

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GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

180 AVENUE LABROSSE
POINT-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE	NR. DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY MO - MO AN - YR	0433553	1/1



VENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR SHIP VIA
DART	GFI-0299	0210444	PO11330
QUANTITÉ QUANTITY	N° DE PIÈCE PART NO.	DESCRIPTION	
3	D4055-3P	TANK AFT END CERTIFICATE OF CONFORMANCE REQ	
	MFG. JOB# <u>J0210444-001</u> QTY <u>3</u> (1) BOX		



REÇU PAR / RECEIVED BY

DATE

EXPÉDITEUR
SHIPPER

NR. DE BON DE LIVRAISON
SHIPPING MEMO NO.



TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION.
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

S
6/6/08

CERTIFICATE NO.	1	OUR JOB NO	J0210444	SHIPPING MEMO	0433553
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
	3 PCS	PO11330	D4055-3P		TANK AFT END
MATERIAL		SUPPLIED BY		DWG ISSUE	
AL 6061-T6		SAMUEL / ALCOA INC		PA1	
MAT. REL. NO.		608951			

PROCESS	PROCESSOR	RELEASE NOTE #
1 FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2 REF. GFI MANUFACTURING JOB NUMBER J0210444-001 (3 PCS)		
3		
4		
5		
6		
7		
8		
9		

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 03 MARCH 2010

G.F.I. Q.C. REP.

Gordon Hanwell



LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5

No 001591859



(514) 457-3399 FAX (514) 457-9393

PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME
ASTERO TRANSPORT

CAMIONTRUCK
099 NOM DE LA BRANCHE/SALES BRANCH NAME
SAMUEL & FILS & CIE (QUEBEC) L

DATED/EXPIRE DATE OF SHIPMENT
2/16/10

VENDU À/SOLD TO:

GFI, DIVISION DE THOMAS & BETTS LTEE
180 LABROSSE

EXPÉDIÉ À/SHIP TO: TAB: PPD
GFI INC.
180 LABROSSE

POINTE-CLAIRES
QC
H9R1A1

(514) 630-4877

POINTE-CLAIRES
QC
H9R1A1

CA

(201009-00001)

N° COMMANDE
N° ITEM
000752-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 76423
4 PCS AL. SH. 6061 T6
.0630"x48"x144"
QQA 250/11

Cert/Test: FAX

174 LVR

#Pièce AS06348144QM

Description	Art	Pd ca	Qté	#Étiq	Vendeur	Org
#Étiq mln	#À soul			Étiq princ	#Coul	
764479	4	192.000	174	4947487	ALR	US
Total:	4	192.000	174	D654824	608951	

Poids total:

#Total paquets:

174 LVR

Commentaires connaissance:

CERTIFICAT DE CONFORMITÉ
LE MATERIEL DETAILLE CI-DESSUS EST CERTIFIÉ
CONFORME AUX EXIGENCES DE VOTRE COMMANDE ET AUX
SPECIFICATIONS DES NORMES DU GRADE. SVP VOUS
RÉFÉREZ AUX CERTIFICATS CI-JOINTS. AUTORISÉ PAR:


MELISSA DIAMOND
ADMINISTRATION

DATE 16/02/10

NIR: R-539477-1

PAR <input checked="" type="checkbox"/> PORT PAYÉ/PREPARD <input type="checkbox"/> PORT DU COLLECT	INST. VOITURIER/DRIVER INSTRUCTIONS	VALEUR (\$2.000b max. moins d'avis contraire) VALUATION (\$Max \$2,000b unless otherwise stated) VALOR DECLARADA DE L'EXPEDITION DECLARED VALUE OF SHIPMENT
CHARGES	VOITURIER/DRIVER	REÇU PAR/RECEIVED BY
EXPEDITEUR/DISPATCHER		

1. ORIGINAL - NON NÉGOCIABLE (CE CONNAISSEMENT DOIT ÊTRE SIGNÉ PAR L'EXPÉDITEUR ET LE VOITURIER)

CERTIFIED INSPECTION REPORT

Alcoa Inc.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet. Per:

Malcolm Murphy
Director of Manufacturing Davenport Works

Kenton P. Young

Kenton P. Young
Quality Assurance Manager

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

Page 1

1058276 Ship Date 2009-10-15	0 B.L. No. 4303234	Invoice No. 00000	Alcoa No. Item 1000143904-6
P.O. No./Govt Contract No. N22238 Ln#: 6		Customer	Alcoa Item SAMUEL SON & CO LT G041110647R02

Ship To: SAMUEL SON & CO LTD
S.S.M.Q
21525 CLARKE-GRAHAM
BAIE D'URFE H9X 3T5 QC

Item Description
0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -.125) X 144.0 IN LN (.+15625 -.15625) (N) A/T 6061-T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-209 REV 07 EXC MRK ASTMB209 REV 07
CMMMP025 REV S CMMMP019 REV D ((MARKED))
KRAFT PAPER INTERLEAVED MAX GROSS
SKID WGT: 4500 LB QUAN TOL +/-30 %
CQR 0222751 REV 02 CUST REQ 09-10-01 *** W/E 09-10-24 ***

Num	Package	Ticket	Lot	Weight	Quantity	UOM	Pc Id/Serl	Inspector	Clock Numbers
1	764477		608951	4119	100	PC	:	27299	47004
2	764478		608951	3408	83	PC	:	27299	47004
3	764479		608951	4149	100	PC	:	27299	47004
				11676	283				

Notes for CQR: 0222751.2
 PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250_11 ORIGINAL REVISION DATED 1997-08-01.

CQR: 0222751.2 -Specification Limits

Tmpr T6	Dir Long Transv.	UTS	TYS	EL4D
		KSI	KSI	PCT
	Max			
	Min	42.0	35.0	10

Chemical Composition Alloy 6061	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other	Aluminum REMAIN
	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	Each	
	Min	0.40	0.15	0.8	0.04						

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet, the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.
Per:

Malcolm Murphy
Malcolm Murphy
Director of Manufacturing Davenport Works

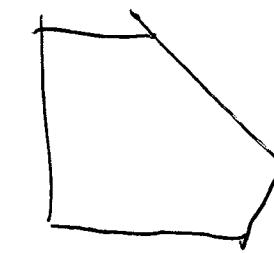
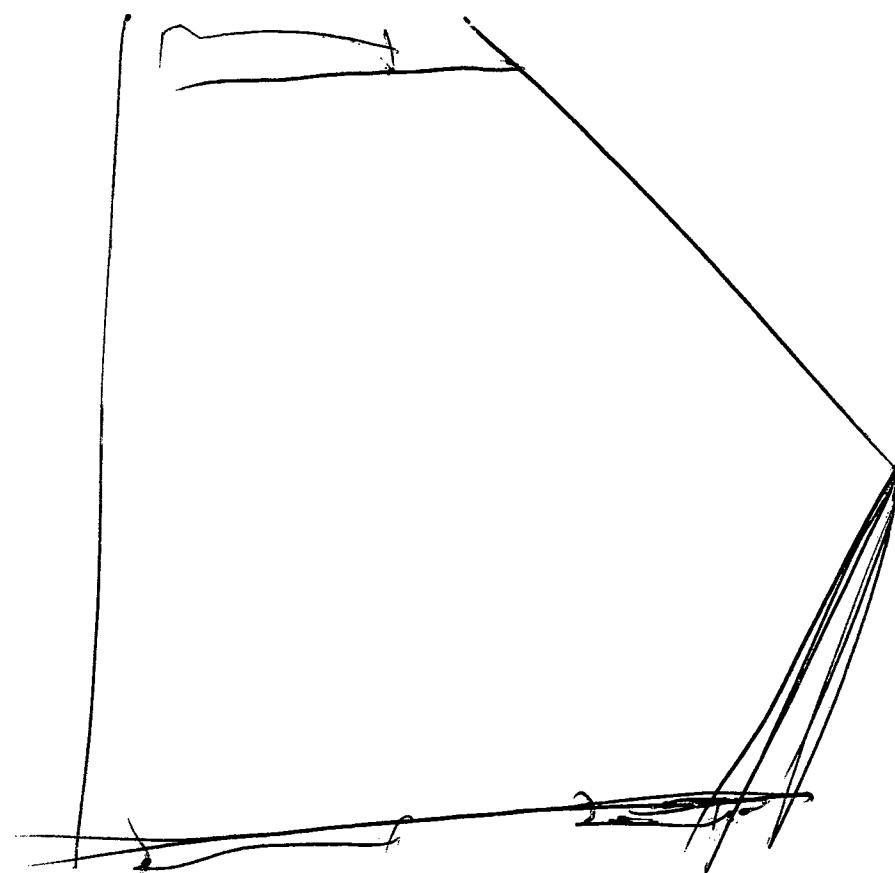
Kenton P. Young
Kenton P. Young
Quality Assurance Manager

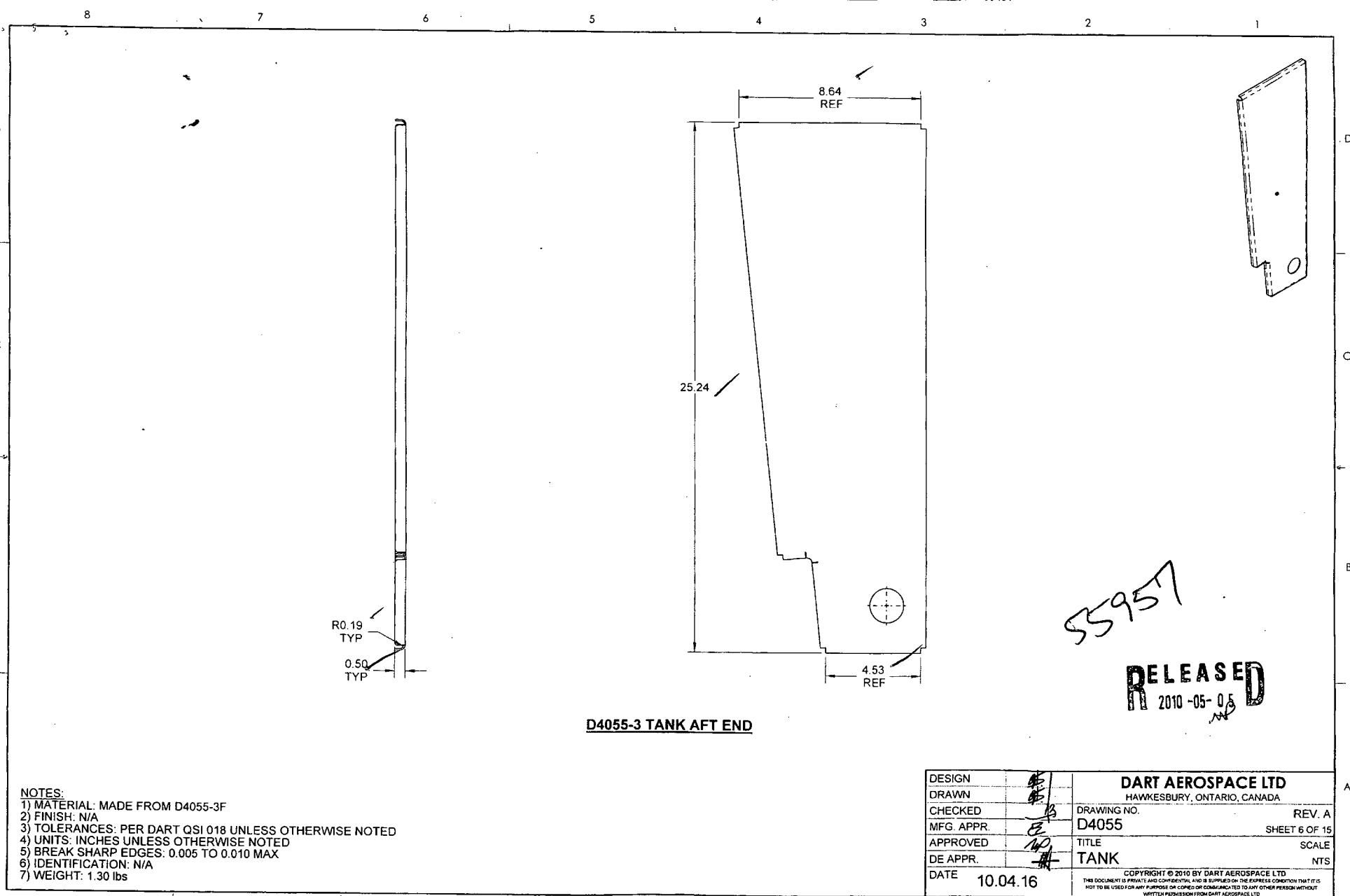
Alcoa Inc.

PITTSBURGH, PA		DAVENPORT WORKS	
Ship From:		RIVERDALE, IA.	
1058276	0	Invoice No.	Alcoa No. Item
2009-10-15	4303234	00000	1000143904-6
P.O. No./Govt Contract No.		Customer	Alcoa Item
N22238 Ln#: 6		SAMUEL SON & CO LT G041110647R02	
Page 2			
DCE-43904-6			

CQR: 0222751.2 -Specification Limits (cont.)
 Lot: 608951 - Mechanical, Physical, Metallography, Quantometer Results
 Tmpr Dir No-> UTS TYS EL4D
 T6 Long Transv. Test KSI KSI PCT
 2 50 44.8 10.9
 49.9 44.8 10.9
 Cast Number Chemical - OES SI FE CU MN MG CR ZN TI
 H8054013 Actuals 0.66 0.5 0.26 0.06 0.9 0.19 0.05 0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States





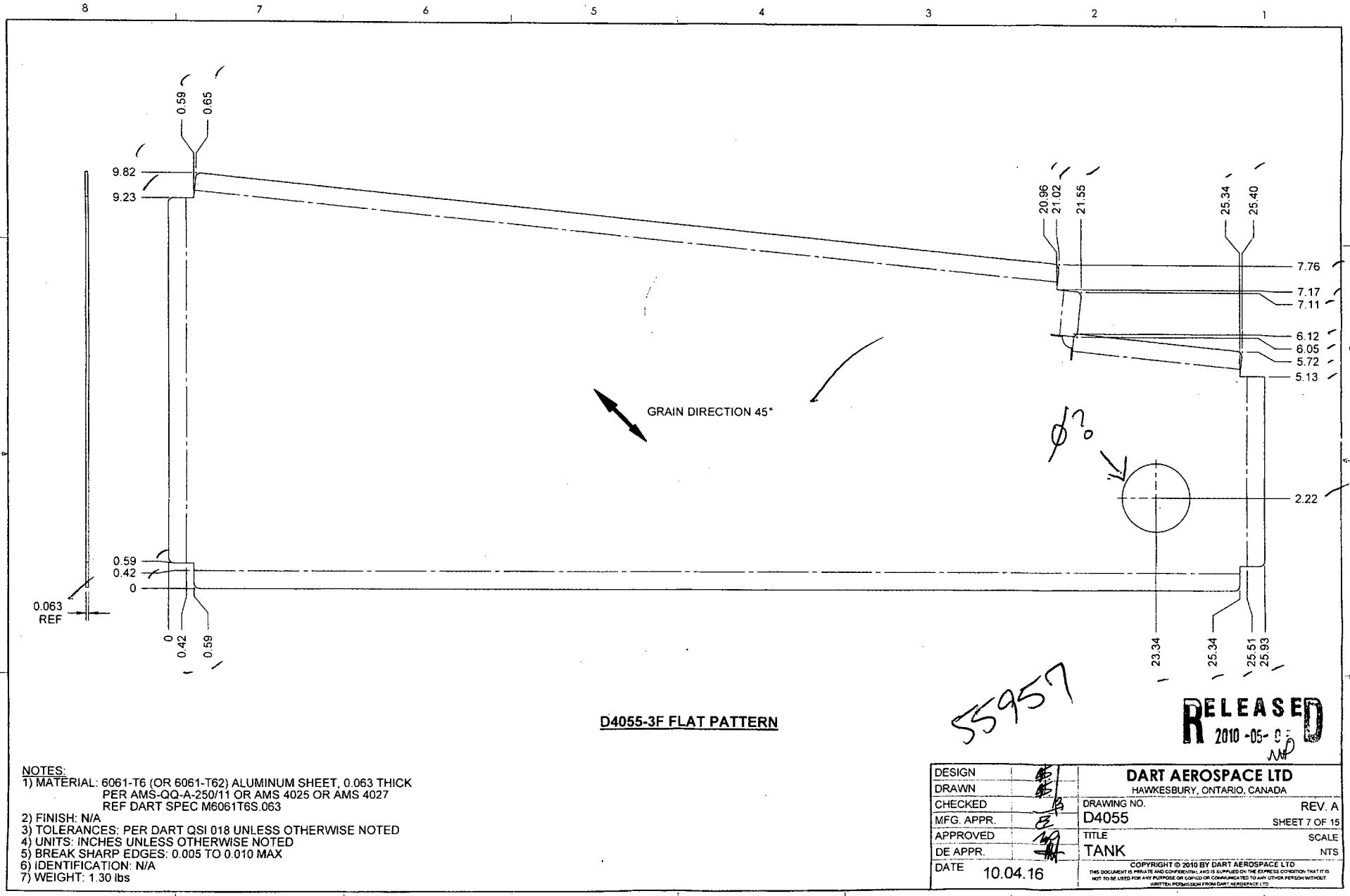
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector		
			Initial Chief Eng	Action Description Chief Eng	Sign & Date					

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____